

Date: Tuesday, 8/7/2007 7:33:39 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	"T" HANDLE ASSEMBLY	
Job Number	33831			
Estimate Number	11179			
P.O. Number	N/A	Part Number	D2282041	
This Issue	8/7/2007	S.O. No.	N/A	
Prsh Rev.	NC	Drawing Number	D2282 REV E	
First Issue	8/7/2007	Type	LARGE FAB ASSY	
Previous Run	33390A	Project Number	N/A	
Written By	<i>JLM 07-08-07</i>	Drawing Revision	E	
Checked & Approved By		Material	N/A	
Comment	Est Rev:A	Due Date	8/14/2007 Qty: 50 Um: Each	
Removed from 9 Digit 05-12-02 JLM				

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	D22823	Tube 

Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-3	Handle tube	<i>B33829</i>

07/08/07 SD

2.0	D22825	Tube 
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-5	Handle tube	<i>A33416</i>

07/08/07 SD

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS Filling Rod *M15712*
Dwg Rev: *E*

07-08-07 SD

4.0	DO NOT USE Q.C.	WELD INSPECTION 
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Comment: WELD INSPECTION

07/08/07 SD

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 33831

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SA

07.08.08



6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/08 (52)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion

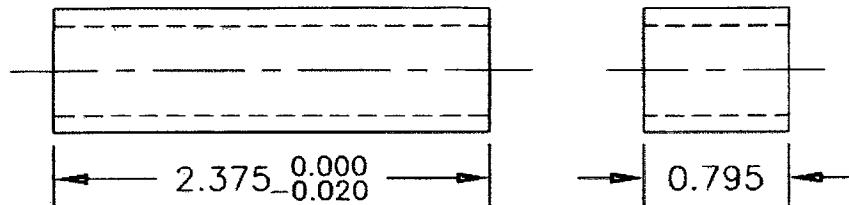


07/08/09



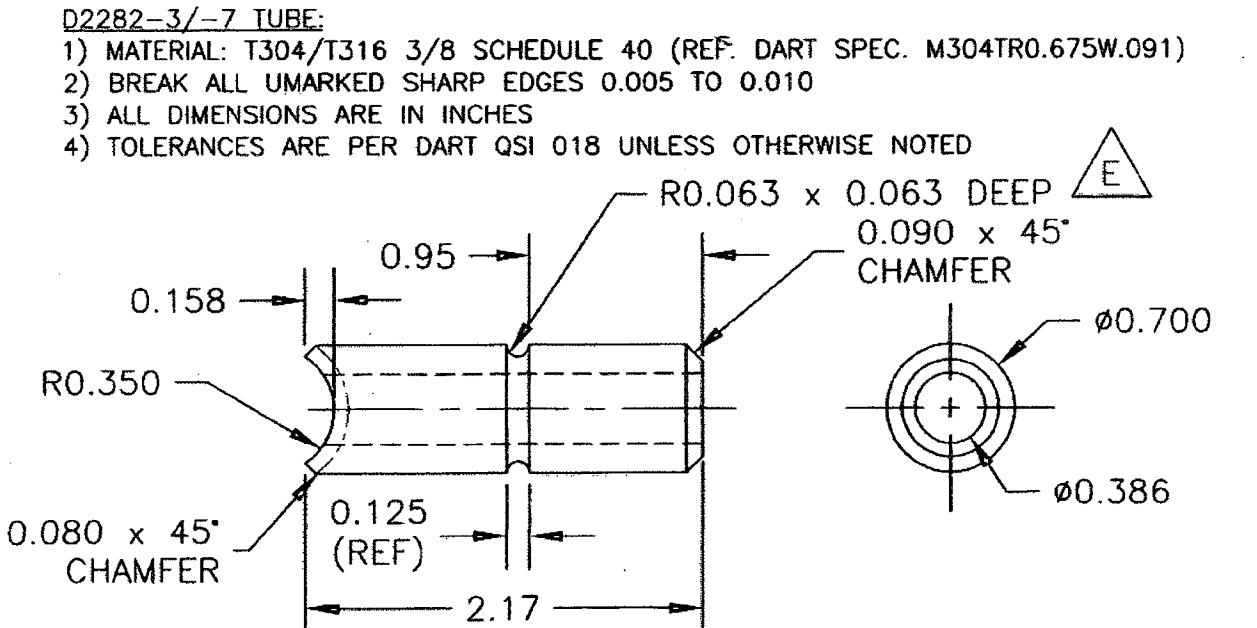
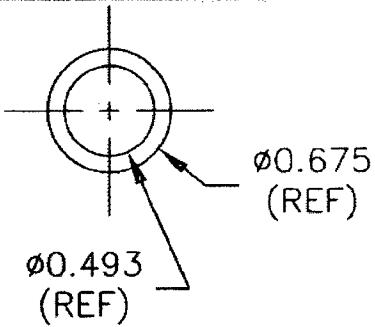
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

*RELEASED
8/09/16*



D2282-3

D2282-7



D2282-5

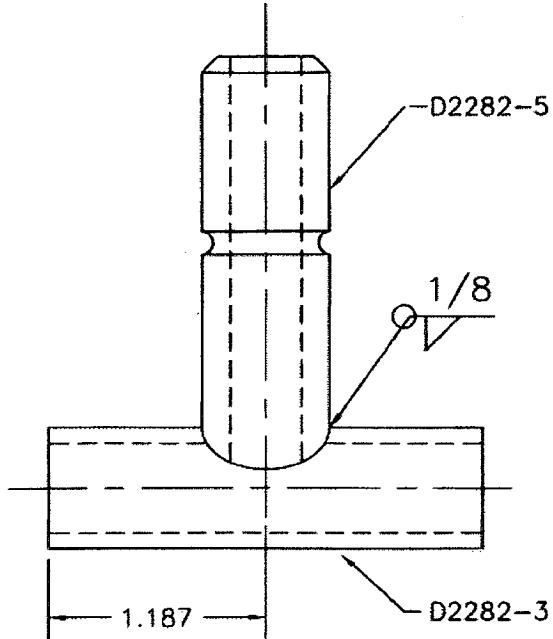
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

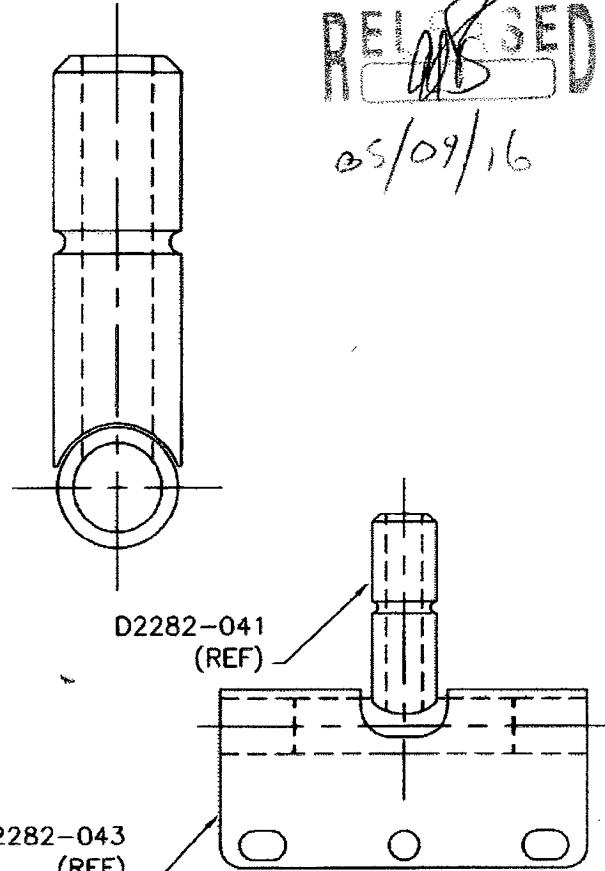




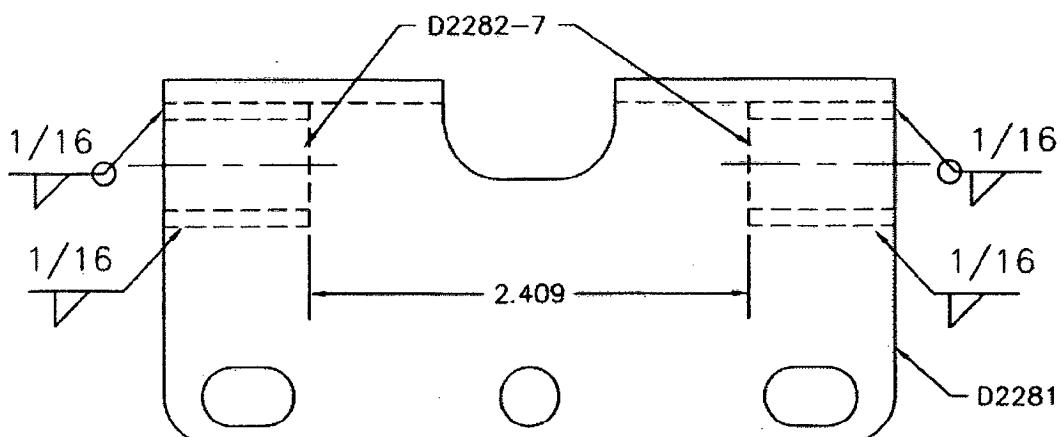
DESIGN BW	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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